

Work Order ID 69713-1 *SPUR*

Tuesday, May 17, 2011 2:48:53 PM



Page 1

Item ID: D2893-1

Revision ID:

Item Name: 2.75 Support *(5)*

Start Date: 5/17/2011 Start Qty: 20.00

Required Date: 6/20/2011 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2893

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

conf 11/06/01

5 0

HAAS CNC vertical machine #1

Machine as per Folio FA081: Tumble & Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

conf 11/06/02

5 0

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

PA 11.6.2

5

Quality Control

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Tuesday, May 17, 2011 2:48:53 PM



Page 2

Item ID: D2893-1

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Setup Start



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Customer:

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Mask Inside Bore for Priming START TIME 9:40
OVEN TEMPERATURE 400 OF FINISH

5x Ø M-L 11/06/03

NL 11 6964

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 BR 11-6-3.

150

SprayPaint

0.00



SprayPaint

Memo

0.00

Spray Painting

Prime inside surface as per Dwg D2893 and QSI 005 4.3

NL 11 06 06 (5)

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Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

11-06-07 (5)

170

Identify as per dvg & Stock Location: X-tube

0.00

Packaging

Memo

0.00

Packaging

11-06-07 (5)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/8

11-06-1 (5)

Picklist Print

Tuesday, May 17, 2011 2:49:04 PM

Page 1

Work Order ID: 69713



Parent Item: D2893-1

Parent Item Name: 2.75 Support

Start Date: 5/17/2011

Required Date: 6/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C 02.11.26 Reformat; Added P/O: HKJ
IPP: D 06.04.19 removed alodine ECU
IPP Rev: E Added priming as per Rev B 07-04-30 JLM
IPP: F 08.03.19 Re-format EC verified by: DD
IPP Rev: G 08-05-15 add QC14 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	0.0000	0.5	10			



D2893-1 TURNING DETAIL

BL9650 X 07

MR 11/06/01

DART AEROSPACE LTD		Work Order:	C9713
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.989	2.990	2.991	2.992	2.990
AB	0.440	0.460		.440	.440	.455	.455	.460
AC	0.125	0.160		.131	.131	.125	.125	.127
AD	0.040	0.060		.049	.049	.049	.049	.051
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.135	.135	.135	.135	.135
AG	0.140	0.160		.151	.145	.153	.183	.150
AH	1.360	1.400		1.368	1.368	1.375	1.376	1.371
AI	0.040	0.060		.052	.051	.057	.053	.052
AJ	1.190	1.230		1.211	1.211	1.220	1.222	1.215
AK	0.010	0.020		.010	.010	.011	.011	.012
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.520	2.520	2.520	2.520	2.520
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.263	.263	.263	.263
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:		Date:	11/06/02
Audited by:	RP	Date:	11.6.5
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

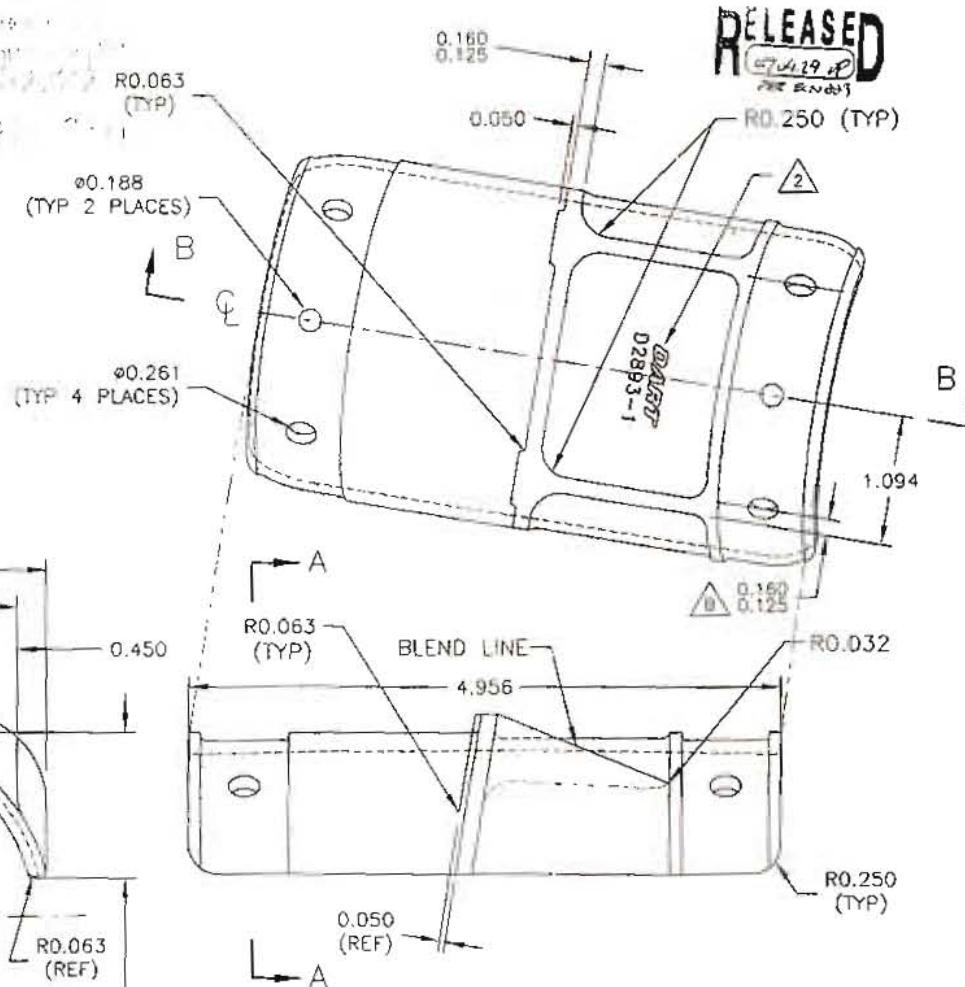
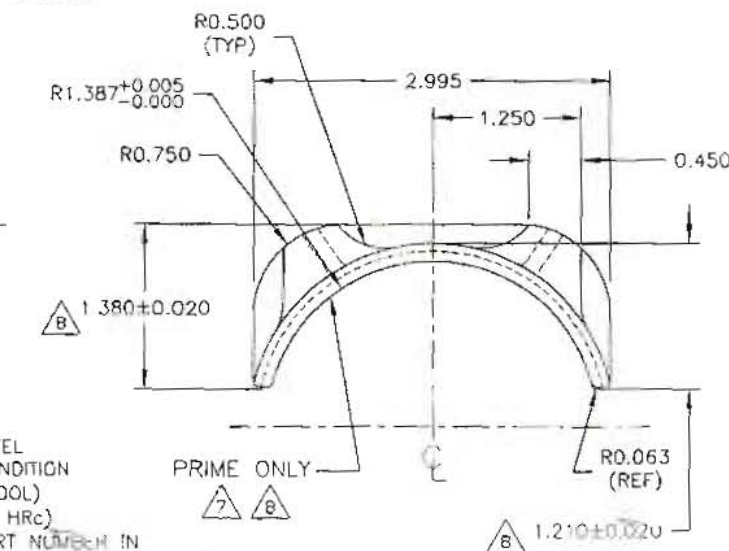
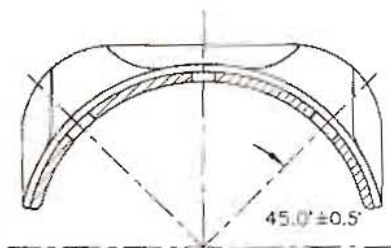
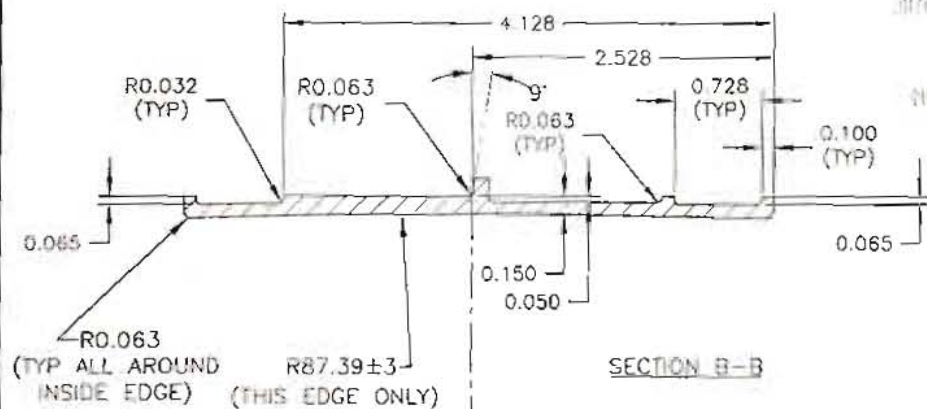
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



02893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	GP	DRAWN BY PH
CHECKED	H	APPROVED H
DATE	07.03.16	
DART	DART AEROSPACE LTD.	
DRAWING NO.	D2893	
TITLE	02 750 SUPPORT	
REV. B		SHEET 1 OF 1
SCALE		